Work Order ID 121116

121116

June-16-14 1:18:49 PM

Item ID: D3404-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: GHW/ Lug

Start Date: 6/16/14 **Start Qty:** 80.00 *80* **Cust Item ID:**

Required Date: 6/16/14 **Req'd Qty:** 80.00 *80* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 14-06-18 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3404 / Rev C									
100		0.00							DAS 37 9-89 14.08.23
100	BAND SAW					80	Ø		
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut blank: 2.700" long								
110		0.00							DAS 37 9-89 14.08.24
110	HAAS CNC VERTICAL MACHINING #1					80	Ø		
HAAS 1	**Memo**	0.00							DAS 44 9-89 14/08/26
HAAS CNC vertical machine #1	1-Machine as per Folio FA555 and Dwg D3404Dwg Rev: C Folio Rev: AB 2-Deburr								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 37 9-89 14.08.24
120						80	Ø		
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Item ID: D3404-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: GHW/ Lug
Start Date: 6/16/14 **Start Qty:** 80.00 *80* **Cust Item ID:**
Required Date: 6/16/14 **Req'd Qty:** 80.00 *80* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00				80	0		
130			14/08/27						
QC	**Memo**	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: WA	0.00				MF	14-10-20		
140									
Packaging	**Memo**	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00					14/10/20		
150									
QC	**Memo**	0.00							
Quality Control									

MF
14-10-20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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General

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☐ BOM/Route
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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Picklist Print

June-16-14 1:18:49 PM

Work Order ID: 121116 *121116*

Parent Item: D3404-1 *D3404-1*

Parent Item Name: GHW/ Lug

Start Date: 6/16/14 **Required Date:** 6/16/14

Start Qty: 80.00 **Required Qty:** 80.00

Comments: IPP Rev:A05.09.01New issueKJ/JLM
IPP rev B 09.01.28 new geometry rev.C EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.750X2.500		Purchased	No			100	f	29.1000	0.2291	20		DAS 37 9-89	

M304B0.750X2.500

304 BAR .750 X 2.50

**

14.08.23

Location	Loc Qty	Loc Code	
MAT007	29.1		
M128496	3.1		
M129240	12.667		
M129287	13.333		

129873

20ft.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Use-as-is ☐
Suspected Unapproved ☐

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Doc/Data	☐									
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Material	☐									
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Offset/Setup	☐									
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Supplier	☐									
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☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
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☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

DART AEROSPACE LTD	Work Order:	121116
Description: GHW Lug	Part Number:	D3404-1
Inspection Dwg: D3404 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	Ø.512	✓			PIN GAUGE
R0.65	+/-0.030	R.65	✓			RAD GAUGE
0.125	+/-0.010	.127	✓		DR16	8" VERN
0.500	+/-0.010	.499	✓			
2.14	+/-0.030	2.140	✓			
1.30	+/-0.030	1.300	✓			
R2.30	+/-0.030	R.230	✓			
1.14	+/-0.030	1.141	✓			
2.58	+/-0.030	2.583	✓			

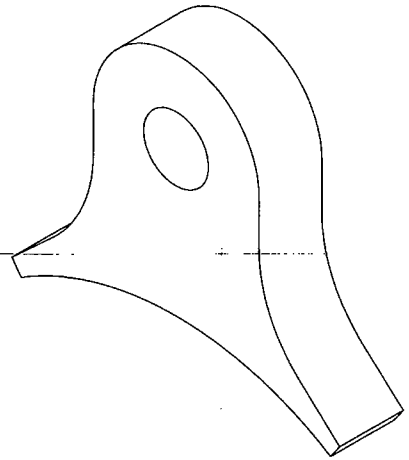
Measured by:	DAS 37 9-89
Date:	14.08.24

Audited by:	
Date:	14/08/27

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.12	New Issue	KJ/JLM	
B	09.05.04	Dimensions updated per Dwg Rev. C	KJ/DD	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 121116 MLS
14-06-18



D3404-1 GHW LUG

RELEASED
06/12/18 MW

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

REV.	DESCRIPTION	BY	DATE
C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3404	REV. C
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE GHW LUG	SCALE NTS
DE APPR.			
DATE	08.12.02		

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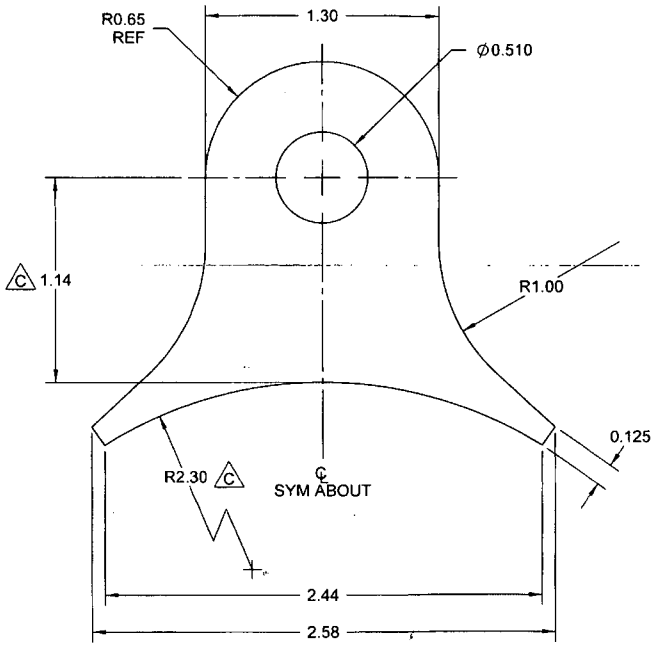

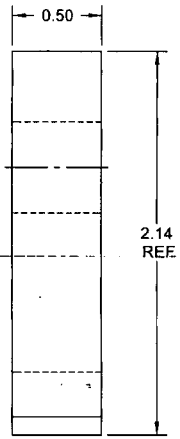

RELEASED
08/12/18 MW

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3404 REV. C SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE GHW LUG SCALE NTS
DE APPR.		
DATE	08.12.02	

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